

Drew 54534

SPLIT 3

Work Order ID 52402 - 3



Page 1

September 22, 2009 11:33:06 AM

Item ID: D3849-043

Revision ID: B

Item Name: AFT WEARPLATE ASSY, STD GEAR

Start Date: 09/23/2009

Start Qty: 2.00

Required Date: 10/02/2009

Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Approvals: Process Plan: MF

Date: 09-09-22 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D3849

B

100



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3849

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

0.00

0.00

IB 9-9-30

(P10) →

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

IB 9-9-30

(7)



# Work Order ID 52402

September 22, 2009 11:33:06 AM



Page 2

Item ID: D3849-043  
 Revision ID: B  
 Item Name: AFT WEARPLATE ASSY, STD GEAR  
 Start Date: 09/23/2009 Start Qty: 2.00  
 Required Date: 10/02/2009 Req'd Qty: 2.00  
 Reference:

Accept



Setup Start



Stop



Cust Item ID:  
 Customer:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00				(17)	4		
130  Brake NC Brake NC	Form as per dwg using DT8179 & DT8155  Memo	0.00 0.00				7	0		
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				(17)	1		

2780210101

09/00/05

27802102





September 22, 2009 11:33:06 AM



Cust Item ID:

**Customer:**



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Insp.  
Stamp

0.00

## Memo

0.00

1- On D3901 bar, fill cut outs with hardcoat welding rod as per dwg D3849  
2059 B Hardcoat Welding Rod  
BATCH#: M 112963

2- Weld D3901 bar to wearplate by positioning holes together as per dwg  
D3849  
304 S.S. Welding Rod  
BATCH #: M102421

QC9- Inspect visual per QSI004- Fusion Welds

0.00

## Memo

### Quality Control

0.00

PD 10.01.05 (3)

x3



# Work Order ID 52402

September 22, 2009 11:33:06 AM



Page 4

Item ID: D3849-043  
Revision ID: B  
Item Name: AFT WEARPLATE ASSY, STD GEAR

Accept



Setup Start



Stop



Start Date: 09/23/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00	⇒ S10101-5			(X3)			
180  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M112558 Memo START TIME: 1:15pm OVEN TEMPERATURE: 320°F FINISH TIME: 1:45pm	0.00  0.00	⇒ M10105101			(X3)	φ		
190  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00	BR 10-01-5			(3)	φ		





**Work Order ID 52402**

September 22, 2009 11:33:06 AM



Page 5

Item ID: D3849-043  
Revision ID: B  
Item Name: AFT WEARPLATE ASSY, STD GEAR

Accept



Setup Start



Stop



Start Date: 09/23/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

200



Small Fab

Small Fab

Memo

1- Bond D3848 gasket to inner surface of wearplate using a thin layer of 3m  
1300/1300L scotch grip adhesive as per dwg D3849  
BATCH: M113174

0.00

0.00

Signature: ES 10/01/14 (3)

210



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Signature: ES 10/01/14

(43)

220



Packaging

Packaging

Identify as per dwg &amp; Stock Location

Memo

0.00

0.00

179

10-1-14 (30SD)



**Work Order ID 52402**

September 22, 2009 11:33:06 AM



Page 6

Item ID: D3849-043  
Revision ID: B  
Item Name: AFT WEARPLATE ASSY, STD GEAR

Accept



Setup Start



Stop



Start Date: 09/23/2009 Start Qty: 2.00



Cust Item ID:

Required Date: 10/02/2009 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Stop



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

230

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/15 *[Signature]*  
MF  
10-1-15



# Picklist Print

September 22, 2009 11:33:05 AM

Page 1

Work Order ID: 52402

Parent Item: D3849-043RevB

Parent Item Name: AFT WEARPLATE ASSY, STD GEAR




Comments:

Start Date: 09/23/2009

Required Date: 10/02/2009

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3848-3RevB 		Manufactured	No				Each	0.0000	2.0000			
Gasket D3901-3RevB 		Manufactured	No				Each	0.0000	2.0000			
Bar M304S18GA 		Purchased	No				sf	183.4395	6.4211			
304/316 .050 Sheet												

B52531 (3)

B53053 3x

9/30/09/14

20 09.12.17

20.4738

189-9-30

## Warehouse

## Loc Qty

## Loc Code

### Location

Main Warehouse

MAT

108156  
111743  
112178

183.4395053  
0.98526316  
23.7174  
158.736842

\_\_\_\_\_  
\_\_\_\_\_  
112178





<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 52402
<b>Description:</b> DFT WEARPLATE ASSY STD GFM2		<b>Part Number:</b> D3844-043
<b>Inspection Dwg:</b> D3844-3 Rev: B		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 375	+0.06 - 0.01	377	*			
125	± 0.10	138	*			
88	± 0.30	880	*			
75	± 0.30	252	*			
2.45	± 0.30	2.45	*			
4.38	± 0.30	4.384	*			
7.00	± 0.30	7.005	*			
51.000	± 0.10	51.000	*			
66.87	± 0.30	66.875	*	73.500"		
Ø 185	+0.05 - 0.01	192	*			
2.433	± 0.10	2.430	*			
6.642	± 0.10	6.639	*			
18.712	± 0.10	18.712	*			
36.629	± 0.10	36.629	*			
62.794	± 0.10	62.794	*			
4.00	± 0.30	4.007	*			
7.72	± 0.30	7.709	*			
1050	± 0.10	1050	*			

<b>Measured by:</b> LB	<b>Audited by:</b> S	<b>Prototype Approval:</b> N/A
<b>Date:</b> 9-9-30	<b>Date:</b> 02/10/61	<b>Date:</b> N/A
<b>Rev</b>	<b>Date</b>	<b>Change</b>
A		New Issue
<b>Revised by</b> KJ/JLM		<b>Approved</b>





8

7

6

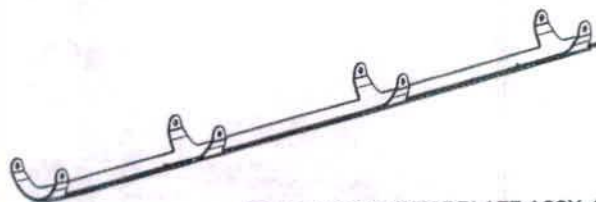
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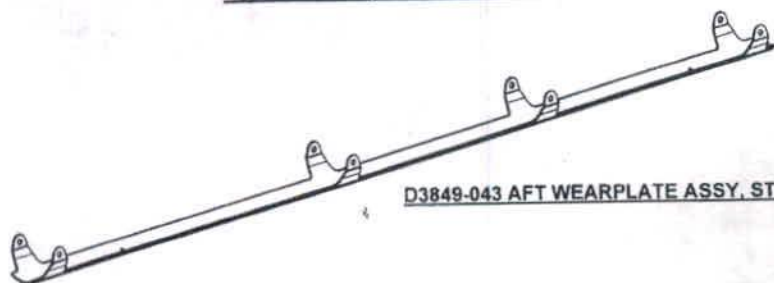
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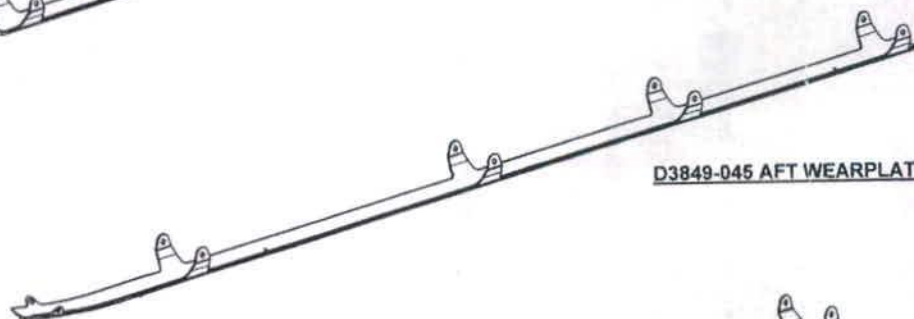
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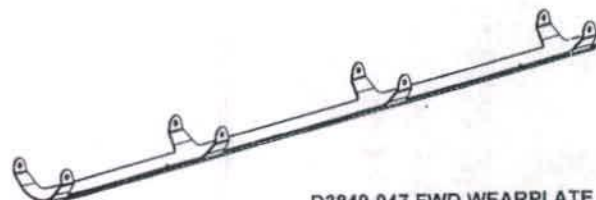
**D3849-041 FWD WEARPLATE ASSY, STD GEAR**



**D3849-043 AFT WEARPLATE ASSY, STD GEAR**



**D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR**



**D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR**

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1				D3848-1	GASKET
16		1			D3848-3	GASKET
17			1		D3848-5	GASKET
18				1	D3848-7	GASKET
19	1			1	D3901-1	BAR
20		1			D3901-3	BAR
21			1		D3901-5	BAR
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (CR 1300L)	3M SCOTCH-GRIP ADHESIVE

#52407

RELEASED  
11/26/15

B		REVISED FLAT PATTERN Ø0.375 WAS SLOT HOLE ON D3849-1F1-3F1-6F (ZN A4-5, B4-7, B4-8, C2-10, B2-10) - ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7-7F (ZN C4-9, A4-9) - ADD SECTION K-K (ZN C5-10) - 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10) - ADD C 25 & 0.88 (ZN D4-10, D3-10) - ADD 0.88 & 0.4 (ZN C3-10 & B3-10) - ADD FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4) - 68, 87 WAS 67.36 (ZN B4-7)		RF	09.06.30
A		NEW ISSUE		RF	09.03.30
REV.		DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC.			
DRAWN	RF	PORT HADLOCK, WA			
CHECKED	PH	DRAWING NO.	REV. B		
MFG. APPR.	CE	D3849	SHEET 1 OF 10		
APPROVED	AM	TITLE	SCALE		
DE APPR.	IF	WEARPLATE ASSY	NTS		
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8

7

6

5

4

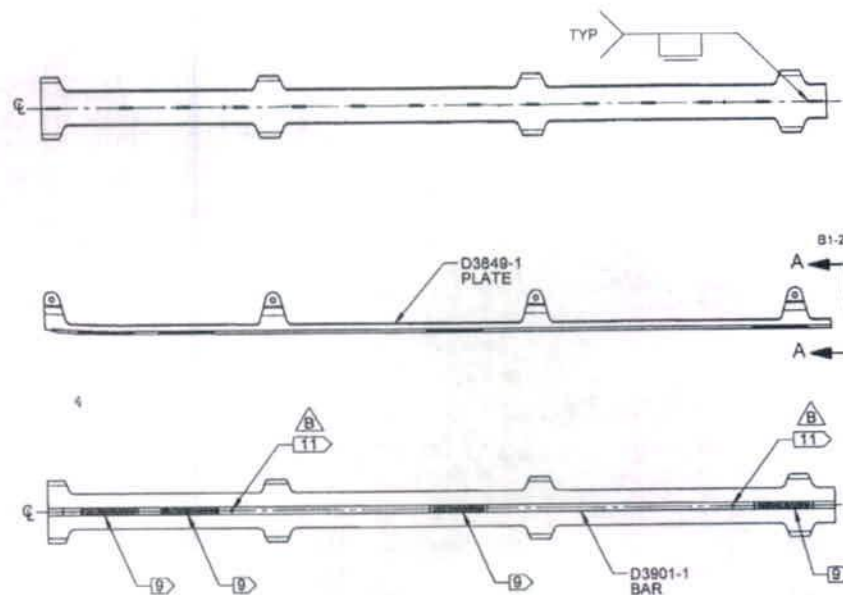
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2

1







**D3849-041 FWD WEARPLATE ASSY, STD/FLOAT GEAR**



**SECTION A-A** C3-2  
SCALE 2X

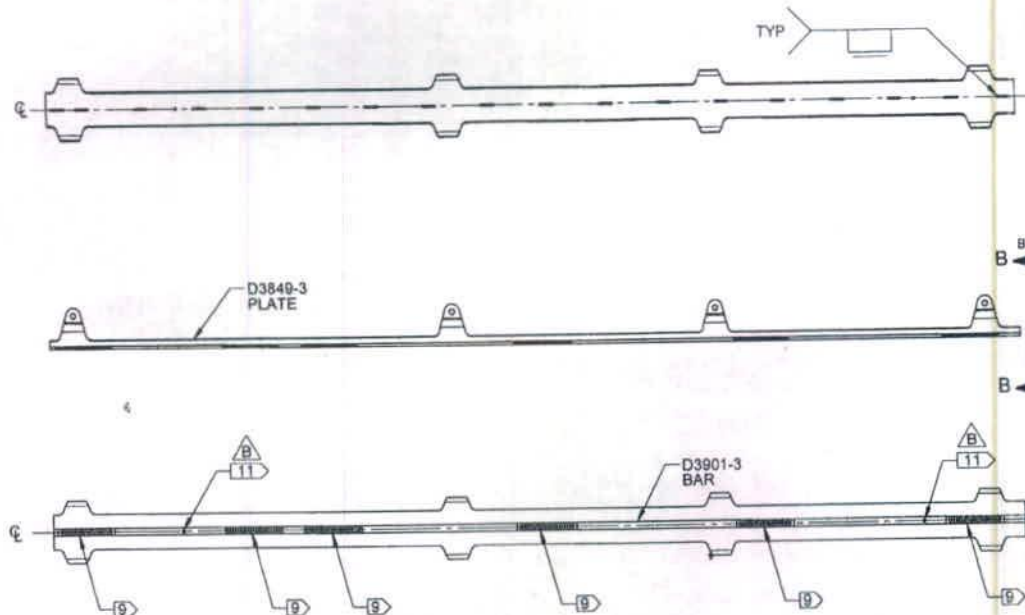
**RELEASED**  
27/07/12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3 5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-041" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-041 = 4.24 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-1 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL  $\varnothing$ 0.188 HOLES FROM D3849-1 PLATE TO D3901-1 BAR

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.		D3849	SHEET 2 OF 10
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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#52402



SECTION B-B C2-3  
SCALE 2X

**D3849-043 AFT WEARPLATE ASSY, STD GEAR**

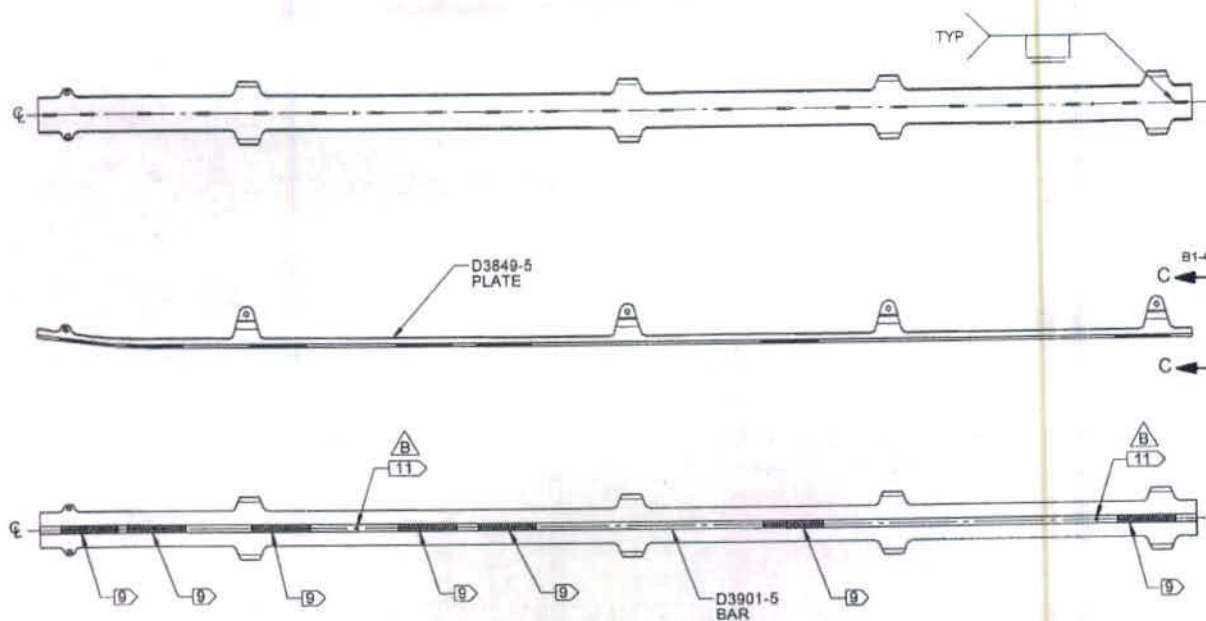
RELEASED  
10/17/12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-043" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3849-043 = 5.21 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-3 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL  $\varnothing 0.188$  HOLES FROM D3849-3 PLATE TO D3901-3 BAR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 3 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	WEARPLATE ASSY	NTS
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# **D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR**

**SECTION C-C** C2-4  
SCALE 2X

**RELEASED**  
09/06/30

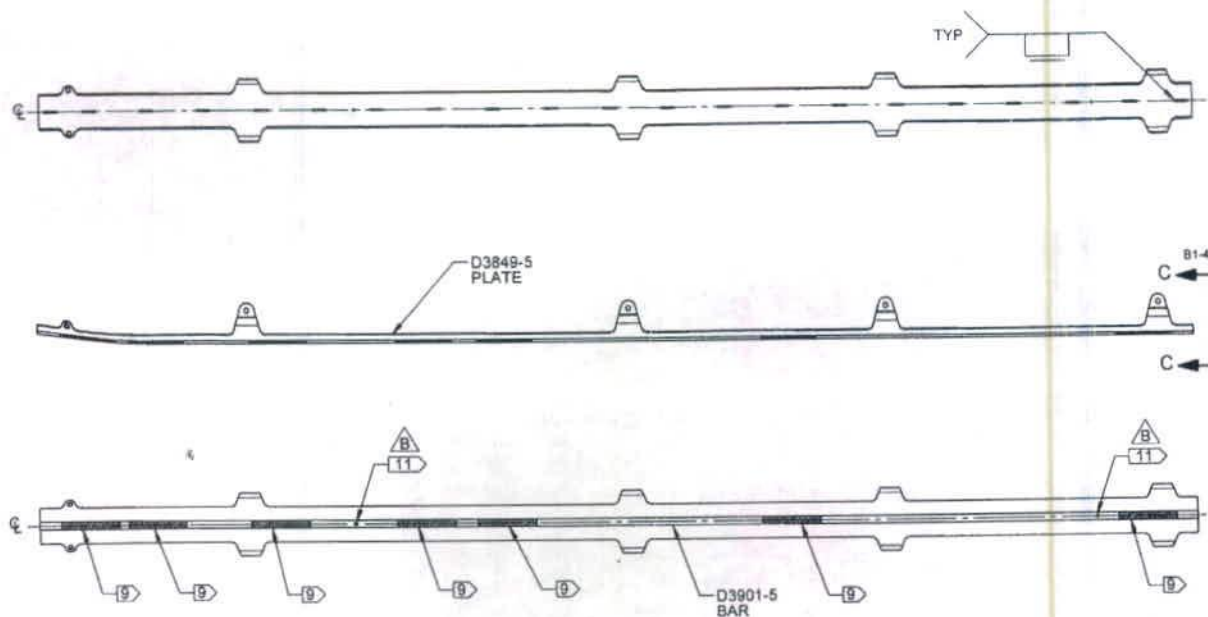
## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-045" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-045 = 5.98 lbs
- 8) WELDING: PER QSI 004
- 9) 20598 HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-5 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL  $\phi 0.188$  HOLES FROM D3849-5 PLATE TO D3901-5 BAR

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. <b>D3849</b>	REV. B
MFG. APPR.	RF	TITLE <b>WEARPLATE ASSY</b>	SHEET 4 OF 10
APPROVED	RF	DATE <b>09.06.30</b>	SCALE NTS
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# **D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR**



**SECTION C-C** C2-4  
SCALE 2X

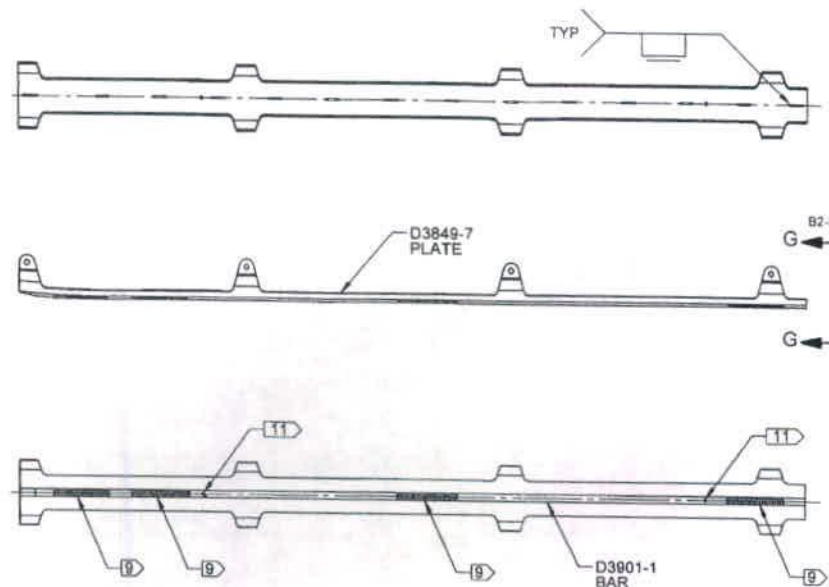
**RELEASED**  
09/06/30

## **NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-045" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-045 = 5.98 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-5 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL  $\varnothing 0.188$  HOLES FROM D3849-5 PLATE TO D3901-5 BAR

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, VA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 4 OF 10
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	<b>WEARPLATE ASSY</b>	NTS
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**D3849-047 FWD WEARPLATE ASSY. FLOAT GEAR**



**SECTION G-G** C3-5  
SCALE 2X

**NOTES**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3849-047" USING YELLOW PAINT MARKER AT INSIDE SURFACE
- 7) WEIGHT: D3849-047 = 4.26 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3848-7 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE
- 11) TRANSFER DRILL  $\phi 0.188$  HOLES FROM D3849-7 PLATE TO D3901-1 BAR

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3849</b>	SHEET 5 OF 10
APPROVED		TITLE	SCALE
DE APPR.		<b>WEARPLATE ASSY</b>	NTS
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#52402

**RELEASED**  
09/07/10 MTP





0.3 REF

R38.5

49.51

D3849-1 PLATE  
(MAKE FROM D3849-1F)

A6-10

#52402

0.050  
REF

7.72

51.313

38.000

DETAIL G

R0.38  
TYP

DETAIL F

A3-10

18.000

C3-10

DETAIL H

2.433

TYP

6.642

4 PL

R0.06

2 PL

Ø 0.188 THRU  
2 PL105°  
TYPR0.50  
TYP4.00  
TYP

4.38

7.00

34.500

54.26 REF

D3849-1F FLAT PATTERN

RELEASED  
09/07/15

## NOTES:

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

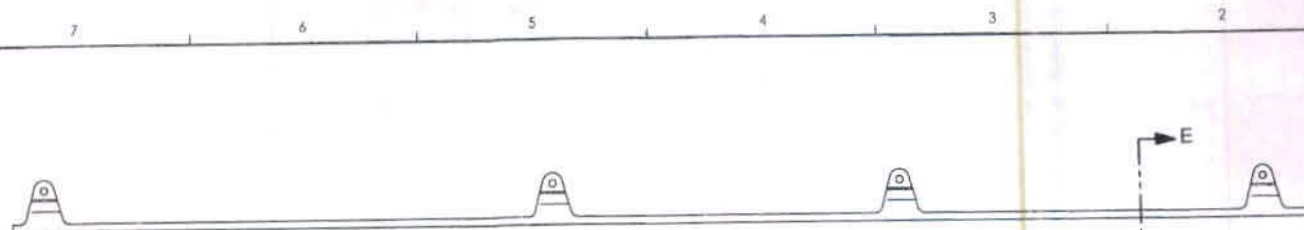
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 2.33 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3849	SHEET 6 OF 10
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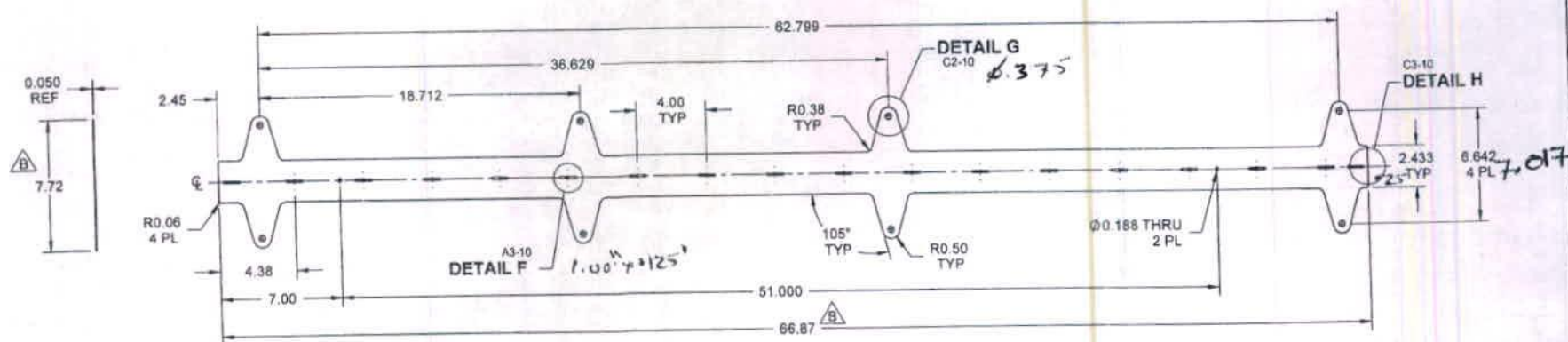




**D3849-3 PLATE**  
(MAKE FROM D3849-3F)

E  
E  
A6-10

#50402



**D3849-3F FLAT PATTERN**

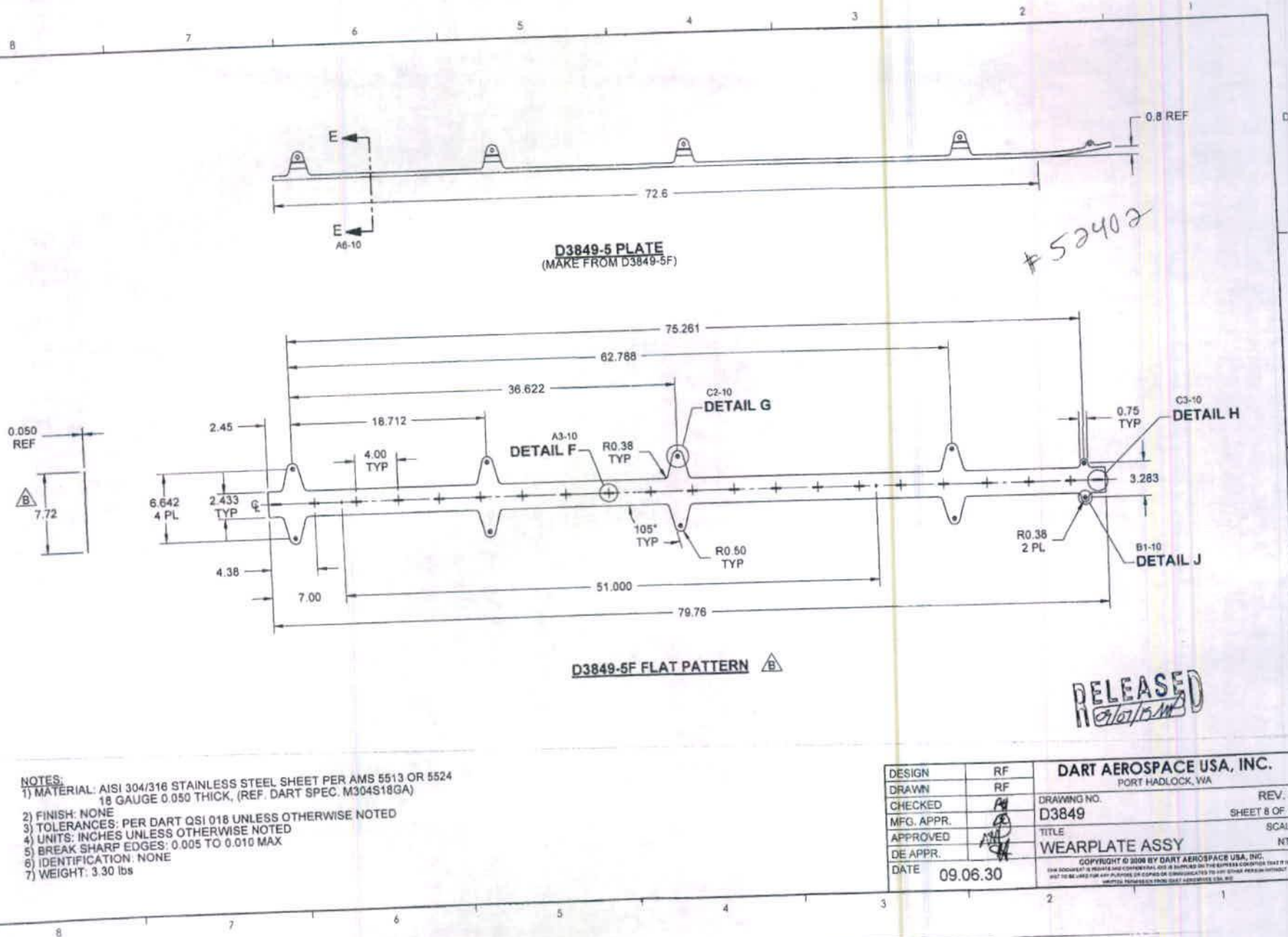
RELEASED  
09/07/15

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.82 lbs

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CHECKED:		DRAWING NO.	REV. B
MFG. APPR.		<b>D3849</b>	SHEET 7 OF 10
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0.3 REF

R38.5

49.51

C5-10

**D3849-7 PLATE**  
(MAKE FROM D3849-7F)

#52402

0.050  
REF

7.88

C2-10  
**DETAIL G**

51.313

36.000

18.000

C3-10

**DETAIL H**R0.38  
TYPA3-10  
**DETAIL F**2.433  
TYP6.801  
4 PL

Ø0.188 THRU  
2 PL

105°  
TYPR0.50  
TYP4.00  
TYP

4.38

R0.06  
2 PL

34.500

7.00

54.26

**D3849-7F FLAT PATTERN**

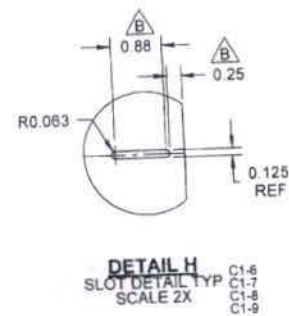
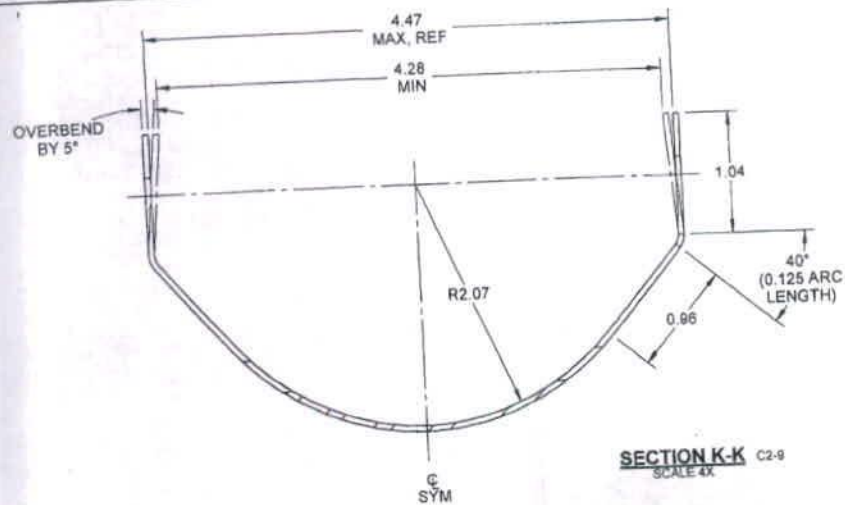
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09/17/15

**NOTES:**

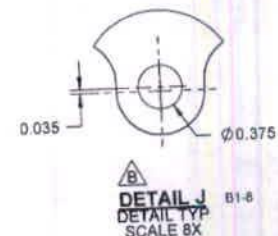
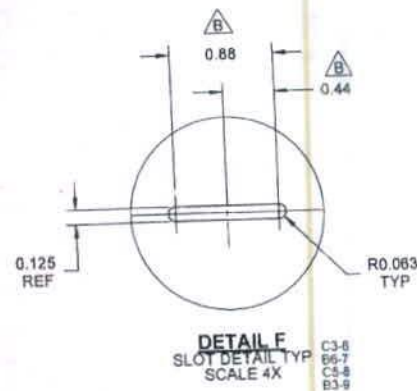
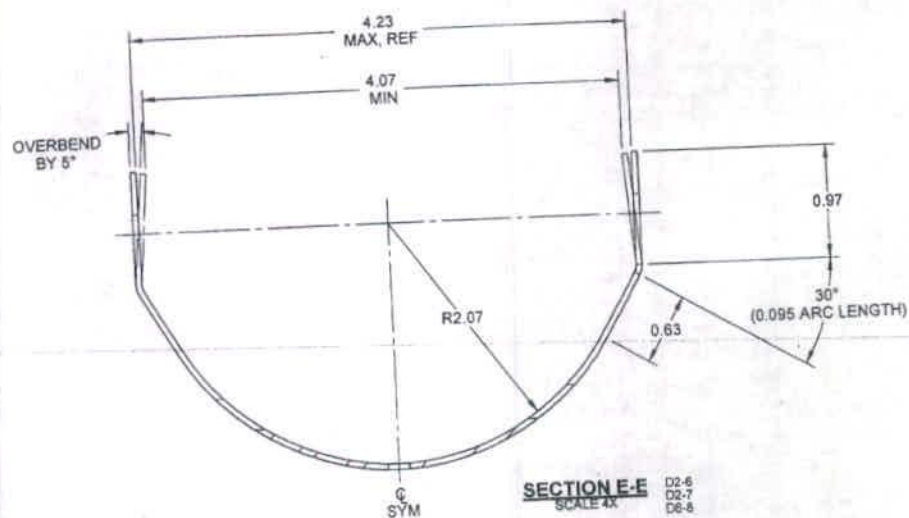
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.34 lbs

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#52402



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10/15/12

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